

Work Order ID 144647-2

April 21, 2016 2:38:56 PM

144647

Needed for Oct 14
Shipment

Page 1

Item ID: D4925-041

Revision ID:

Item Name: Mounting Plate Assembly

Start Date: 5/5/2016

Start Qty: 15.00

Required Date: 5/26/2016

Req'd Qty: 15.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 12/16/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4925

D

100

0.00

100

Small Fab

Small Fab

Memo

1.20

Small Fab

Rivet nutplate to D4925-1 as per dwg.

14

16/09/15

DAS
36
9-89

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.30

Quality Control

14

38
9-89

SEP 16 2016

Work Order ID 144647

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Item ID: D4925-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Plate Assembly
 Start Date: 5/5/2016 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 5/26/2016 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Powdercoat Powder Coating	Gloss Black (Alum) (Ref:QSI005 4.3.5.13) Small Fab Memo <i>11/22/28</i> ***Insert screw BY HAND in nutplate prior to powdercoating*** START TIME: <i>11:50</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>12:20</i>	0.00 1.20							<i>14</i> <i>φ</i> <i>1609-22</i> <i>DAS</i> <i>34</i> <i>9-89</i>
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.15							<i>(14)</i> <i>DAS</i> <i>38</i> <i>9-89</i> <i>SEP 22 2016</i>
135 *135* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.30							<i>(14)</i> <i>DAS</i> <i>38</i> <i>9-89</i> <i>SEP 22 2016</i>

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Item ID: D4925-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Plate Assembly
Start Date: 5/5/2016 Start Qty: 15.00 ***15*** Cust Item ID:
Required Date: 5/26/2016 Req'd Qty: 15.00 ***15*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <i>ST216</i>	0.00							
140									
Packaging	Memo	0.15							
Packaging									<i>DAS 6-89</i>
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	1.50							
Quality Control									

SEP 23 2016

DAS
21
9-89

SEP 23 2016

DAS
21
9-89

SEP 23 2016

Picklist Print

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Work Order ID: 144647

144647

Parent Item: D4925-041

D4925-041

Parent Item Name: Mounting Plate Assembly

Start Date: 5/5/2016

Required Date: 5/26/2016

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 13.10.01 new issue DD verf:JLM IPP REV:B
14.01.13 AS PER DWG REV.A DD VERF:JLM IPP REV:C 15.06.17
AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4925-1		Manufactured	No			100	Each	0.0000	1	15			
D4925-1													
EAPS Mounting Plate													
LN29985-A05		Purchased	No			100	Each	153.0000	6	90			
LN29985-A05													
Anchor Nut													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st555		113							
				m133062		113							
				ST563		40							
				m134586		40							
MS20426AD3-4		Purchased	No			100	Each	6,147.000	12	180			
MS20426AD3-4													
RIVET													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CCK004		4885							
				m134294		4885							
				GA		996							
				m131697		996							
				ST312		266							
				m131697		266							

B 145798

**

16/09/15

DAS
36
9-80

**

16/09/15

DAS
36
9-80

134976 84K

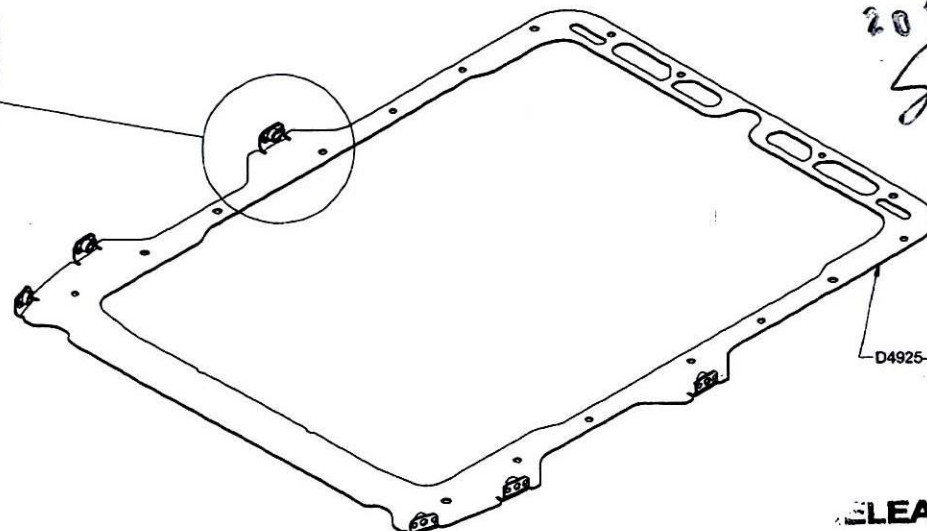
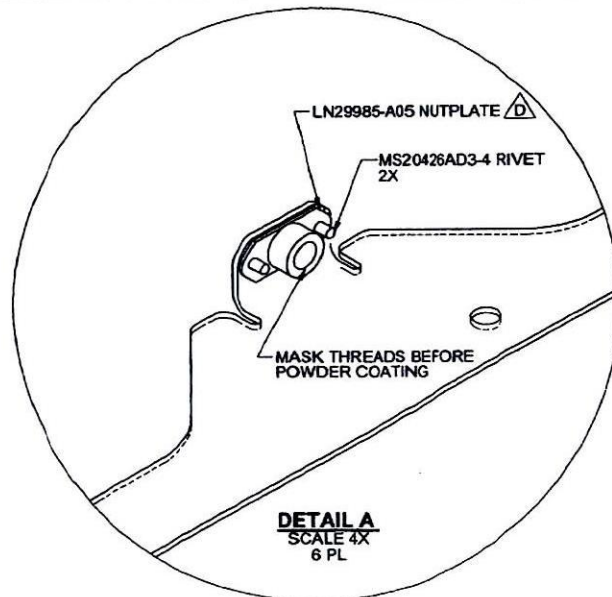
**

15/09/15

DAS
36
9-80

168

ITEM	QTY	P/N	DESCRIPTION
	X	D4925-041	EAPS MOUNTING PLATE ASSY
1	1	D4925-1	EAPS MOUNTING PLATE
2	6	LN29985-A05	NUTPLATE (LN29885-AM5)
3	12	MS20426AD3-4	RIVET, CSK



20160425
SH
144647

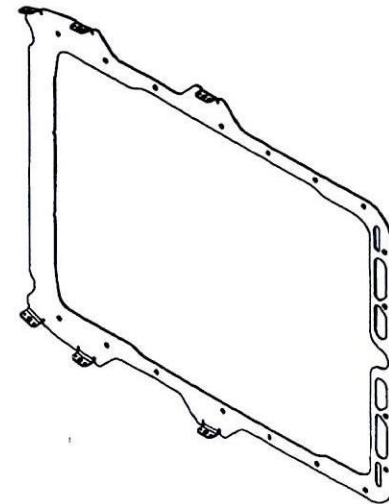
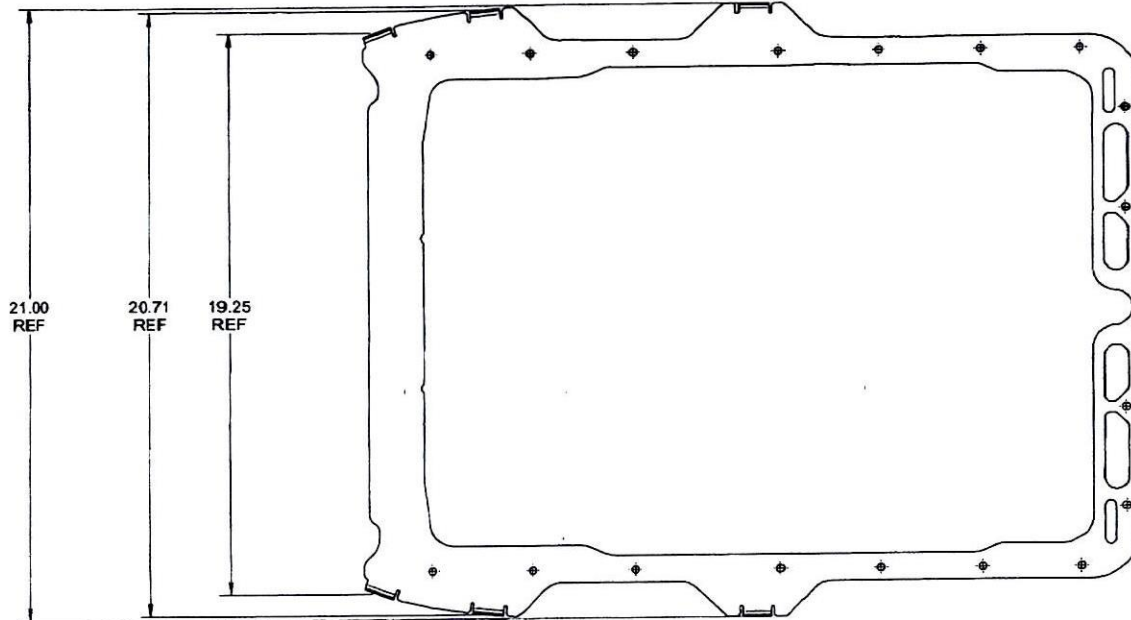
RELEASED
2015 JUN 16
ECN 15-527

D4925-041 EAPS MOUNTING PLATE ASSY

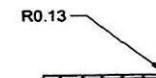
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "BLACK GLOSS" (4.3.5.13) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4925-041" PER QSI 044 6.1
 - 7) WEIGHT: 0.27 LBS

D	UPDATED BOM (LN29985-A05 WAS MS21059L3), REVISED DETAIL C; ZN B2-3	AK	15.03.06
C	REMOVE SLOTS (5 PL) AND EDGE SCALLOP DETAIL	DB	14.04.04
B	COMPLETE RE-DESIGN, SEE REV A FOR DETAILS	DB	14.01.15
A	NEW ISSUE	DB	13.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4925	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	EAPS MOUNTING PLATE	NTS
DATE	15.03.06	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



D4925-1 EAPS MOUNTING PLATE
(MAKE FROM D4925-1F)



SECTION B-B
SCALE 2X

RELEASED
2015 JUN 16

- NOTES:**
- 1) MATERIAL: MAKE FROM D4925-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

APPROVED

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4925	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	EAPS MOUNTING PLATE	NTS
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